

Date: Friday, 9/15/2006 11:59:41 AM
 Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : GUIDE
 Job Number : 28617
 Estimate Number : 11216
 P.O. Number : NIA Part Number : D33335
 This Issue : 9/15/2006 S.O. No. : N/A Drawing Number : D3333 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : NIA Type : MACHINED PARTS Drawing Revision : B
 Previous Run : NIA Material : NIA
 Written By : Due Date : 10/5/2006 Qty: 20 Um: Each
 Checked & Approved By : *[Signature]*
 Comment : Est. A05.01.13 New issue KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010B1500X01000 AISI 1010-1025 Steel Bar



Comment: Qty.: 0.6672 f(s)/Unit Total: 13.3434 f(s)

AISI 1010-1025 Steel Bar

Material: AISI 1010-1025 or ASTM A36/A366/A569/A570 Cold Rolled Steel

(M1010-B1.500x01.000)

Identify for D3333-5

Batch: M102248

[Signature] 06/10/03

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks: 1.500" x 1.000" thick x 7.500" long

[Signature] 06/10/03

20

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA484 and Dwg D3333

Tap holes as per Dwg D3333

Deburr

Identify as D3333-5

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



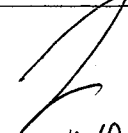




Comment: INSPECT PARTS AS THEY COME OFF MACHINE

[Signature] 06/10/11 x 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 06/11/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/10/10	± 20	one part was cut too short. 7.443" instead 7.500".		Part acceptable, re-take offset to adjust hole pattern.	 06/10/11	 06-10-10	 06-10-10	 06-10-10

NOTE: Date & initial all entries

Date: Friday, 9/15/2006 11:59:41 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE

Job Number: 28617

Part Number: D33335

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JL 06/10/11

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

Ensure to mask threaded holes

M18052

YL 06/10/30

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

LB 06/10/31 (20)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS

LB 06/10/31 (20)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(20) 06/11/01

Job Completion



C Loc 11/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

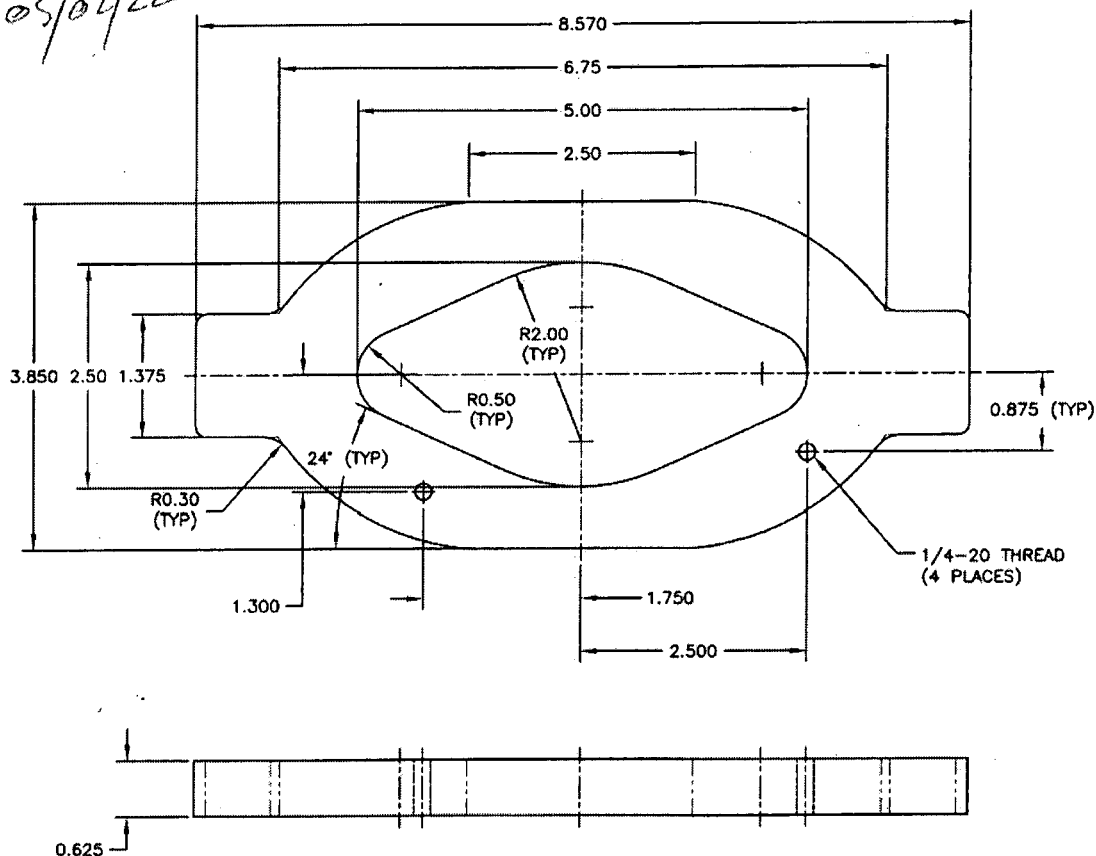
NOTE: Date & initial all entries

DART

DESIGN FE	DRAWN BY FE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 3	APPROVED [Signature]	DRAWING NO. D3333	REV. B SHEET 1 OF 3
DATE 05.02.18		TITLE PLATE	SCALE 1:2
A	04.12.14	NEW ISSUE	
B	05.02.18	RE-DESIGN D3333-3	

RELEASED
[Signature]

05/02/22

**D3333-1 BASE PLATE PANEL****NOTES:**

- 1) MATERIAL: AISI 4140 STEEL 0.625 THICK STEEL (REF. DART SPEC. M4140-B) MIN. YIELD TENSILE STRENGTH = 100 ksi
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WITHOUT NOTICE

WORK ORDER

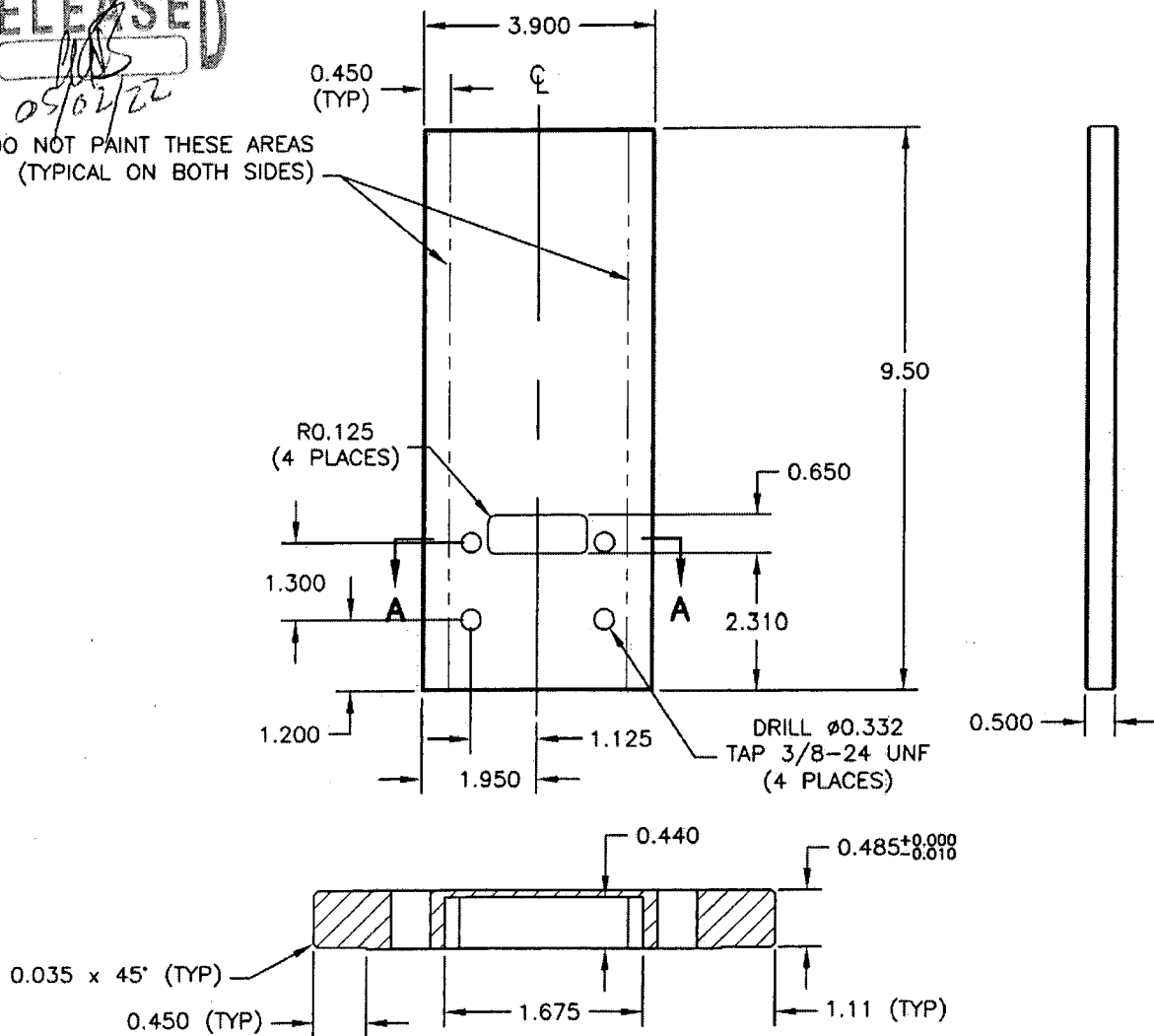
NO. 28617

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CHECKED H	APPROVED H	DRAWING NO. D3333	REV. B SHEET 2 OF 3
DATE 05.02.18		TITLE PLATE	SCALE 1:4

RELEASED
05/04/22DO NOT PAINT THESE AREAS
(TYPICAL ON BOTH SIDES)**SECTION A-A****D3333-3 SLIDING PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 0.50 THICK MILD STEEL (REF. DART SPEC. M1010-B)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

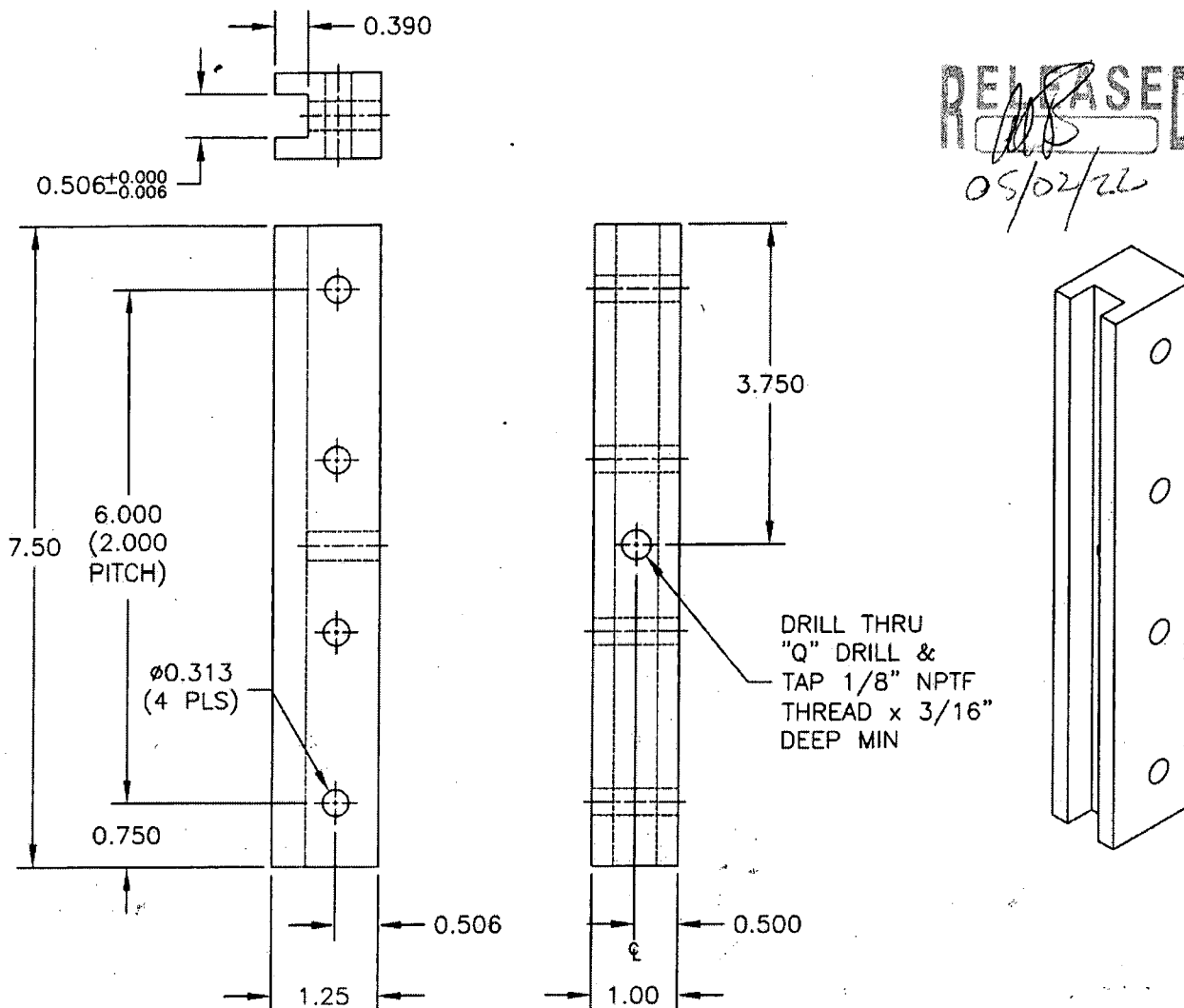
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DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3333	REV. B SHEET 3 OF 3
DATE 05.02.18		TITLE PLATE	SCALE 1:2



D3333-5 RAIL

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.00 THICK STEEL (REF. DART SPEC. M1010-B)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3 WITHOUT NOTICE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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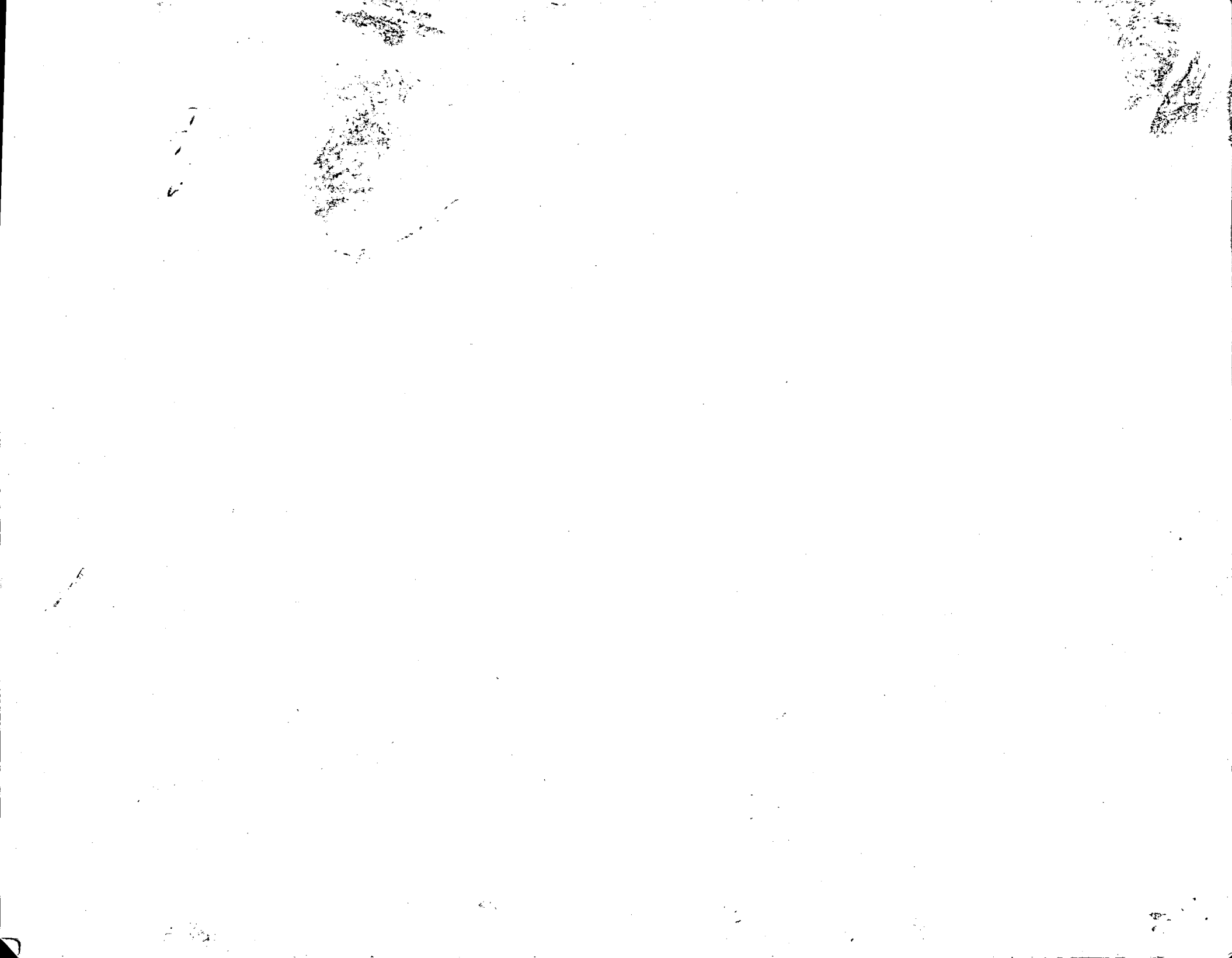
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0498
0511



DART AEROSPACE LTD		Work Order: 286/7
Description: RAIL		Part Number: D3333-5
Inspection Dwg: D3333 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.506	+0.000 -0.006	0.502	✓			
0.390	±0.010	0.390	✓			
7.50	±0.030	7.563	✓			
0.750	±0.010	0.749	✓			
φ 6.313	+0.006 -0.001	0.314	✓			
6.000	±0.010	5.995	✓			
2.000	±0.010	1.996	✓			
1.25	±0.030	1.261	✓			
0.506	±0.010	0.509	✓			
1.00	±0.030	1.004	✓			mat. Dim.
0.500	±0.010	0.498	✓			
3.750	±0.010	3.748	✓			

Measured by: En	Audited by: MS	Prototype Approval: w/a
Date: 06/10/10	Date: 06/10/10	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	